

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015152**Date Inspected:** 22-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Jim Cunningham and Bernie Docena			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder		

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG L4E/L5E side plate 'C' (1000mm to 4770mm) inside, QA randomly observed ABF/JV qualified welder Sungtao, Huang ID # 3794 continue perform CJP groove (splice) welding fill pass. The welder was observed perform automatic welding in the 3G (vertical) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042A-1. The joint being welded has a single V-groove butt joint with backing bar. The splice joint was preheated and maintained to greater than 200 degree Fahrenheit using Miller Proheat 35 Induction Heating System located at the opposite side of the plate prior/during welding. During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters of the welder.

At OBG L4E/L5E bottom plate 'D' outside, ABF welder Mitch Sittinger was observed perform alternately back gouging and grinding on the splice butt joint backing bar removal of 'D' plate. The welder was using Esab plasma arc gouging machine mounted to a track. During the shift, gouging and grinding of the backing bar and some of the base metal were not completed and should continue tomorrow.

At crossbeam number 4 outside, QA randomly observed ABF welder Rick Clayborn perform fillet welding on two sides of four temporary attachment plates. The plates that were connected to the support bracket that will hold the Cabrillo Elevator tower was welded on top of the cross beam. The welder was using Shielded Metal Arc Welding

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(SMAW) with 5/32" diameter E7018H4R electrode. QA noted ABF QC Steven Mc Connell monitoring the welder.



Summary of Conversations:

ABF QC Mike Johnson informed this QA that approved supporting documents for the fillet welding of four attachment plates on top of cross beam number 4 were available to QC. But when QA asked QC to show the documents QC said they were not on site. Due to this, an Incident Report was generated.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Mohammad Fatemi (916) 227-5298, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
